

Tuesday, 9/11/2007 10:24:31 AM
User: Kim Johnston

Process Sheet

40

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HELI UTILITY BASKET LH/RH
Job Number : 34531
Estimate Number : 10197
P.O. Number : N/A Part Number : D350607041
This Issue : 9/11/2007 S.O. No. : N/A Drawing Number : D350-607 REV F P7-9
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : F
Previous Run : 34278 Material : N/A
Written By : Kim Johnston Due Date : 9/30/2007 Qty: 1 Um: Each
Checked & Approved By : Kim Johnston
Comment : Est Rev M 05.09.02 Added D2856-400-720 KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD350-607-041 CHG006

KJ 07.09.12 (1)

2.0 34531A BASKET BASE ASSEMBLY (350)



Comment: Sub-Component BASKET BASE ASSEMBLY (350)

D2221 B 34531A

SAD 07-10-09 (1)

3.0 34531B 350/212/130 BASKET LID



Comment: Sub-Component 350/212/130 BASKET LID

D2512 B 34531B

SAD 07-10-09 (1)

4.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick: Assembly Kit

5.0 D2022101 Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2022-101 Spacer 30543

SAD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 9/11/2007 10:24:31 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI.UTILITY BASKET LH/RH

Job Number: 34531

Part Number: D350607041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2258200

Weight Placard 200lb



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 D2258-200

Label

B 32274

CU

7.0

D2332041

Lid Prop Assembly 6.69"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 D2332-041

Prop Ass'y

32572

CU

8.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 D2530

Handle Weldment

32573

CU

9.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 D2535

Spring

31486

CU

10.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 D2537

Bushing

B 32574

CU

11.0

D27283

Dart Logo label large



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 D2728-3

Label

22553

CU

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: HELI UTILITY BASKET LH/RH

Job Number: 34531

Part Number: D350607041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D2931

Bumper



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 D2931

Bumper

B21137

CU

13.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN3-16A

Bolt

M104093

CU

14.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN4-7A

Bolt

M102140

CU

15.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 AN4-22A

Bolt

M102959

CU

16.0

AN424A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 AN4-24A

Bolt

M101938

CU

17.0

AN517A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN5-17A

Bolt

M109885

CU

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: HELI.UTILITY BASKET LH/RH

Job Number: 34531

Part Number: D350607041

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN960JD8

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN960JD8 Washer M105516

Handwritten signature

19.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN960JD416 Washer M104746

Handwritten signature

20.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN960JD416L Washer M105408

Handwritten signature

21.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN960JD516 Washer M104106

Handwritten signature

22.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN970-4 Washer M104888

Handwritten signature

23.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 MS20600AD4W3 Rivet M104718

Handwritten signature

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH

Job Number: 34531

Part Number: D350607041

Job Number:



Seq. #:

Machine Or Operation:

Description:

24.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3) M104625

LO

25.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS21042L4 Nut (or -4) M104683

LO

26.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS21042L5 Nut (or -5) M104812

LO

27.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D350-607

Seal support gusset seam with white sikaflex-291 Batch: M105488

Expiry date: 07/2008

SAD 07-10-04 *Q*

28.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ES 02/10/04

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick: Packing Kit

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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User: Kim Johnston

Process Sheet

Customer: CU-DAR001, Dart Helicopters Services

Drawing Name: HELI.UTILITY BASKET.LH/RH.

Job Number: 34531

Part Number: D350607041

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

D22301

Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 D2230-1

Lug

B32163-

31.0

D22303

Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 D2230-3

Clamp

B30993-

32.0

D23241

Strut Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 *D2324-1

Strut Ass'y

B32278-

33.0

D2856400

Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total : 0.6000 f(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 D2856-400-720 Abrasion Strip

B27545-

34.0

AN412A

Bolt



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

5 AN4-12A

Bolt

M105143-

35.0

AN413A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN4-13A

Bolt

M105426-

EPot/10/04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 12 Date: 07/10/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 9/11/2007 10:24:31 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH

Job Number: 34531

Part Number: D350607041

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

AN960JD416

Washer



Comment: Qty.: 26.0000 Each(s)/Unit Total : 26.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

26 AN960JD416

Washer

1104746

37.0

MS21042L4

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

13 MS21042L4

Nut (or -4)

1104683

38.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

39.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350607-041

Location:

40.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



1104746-05

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

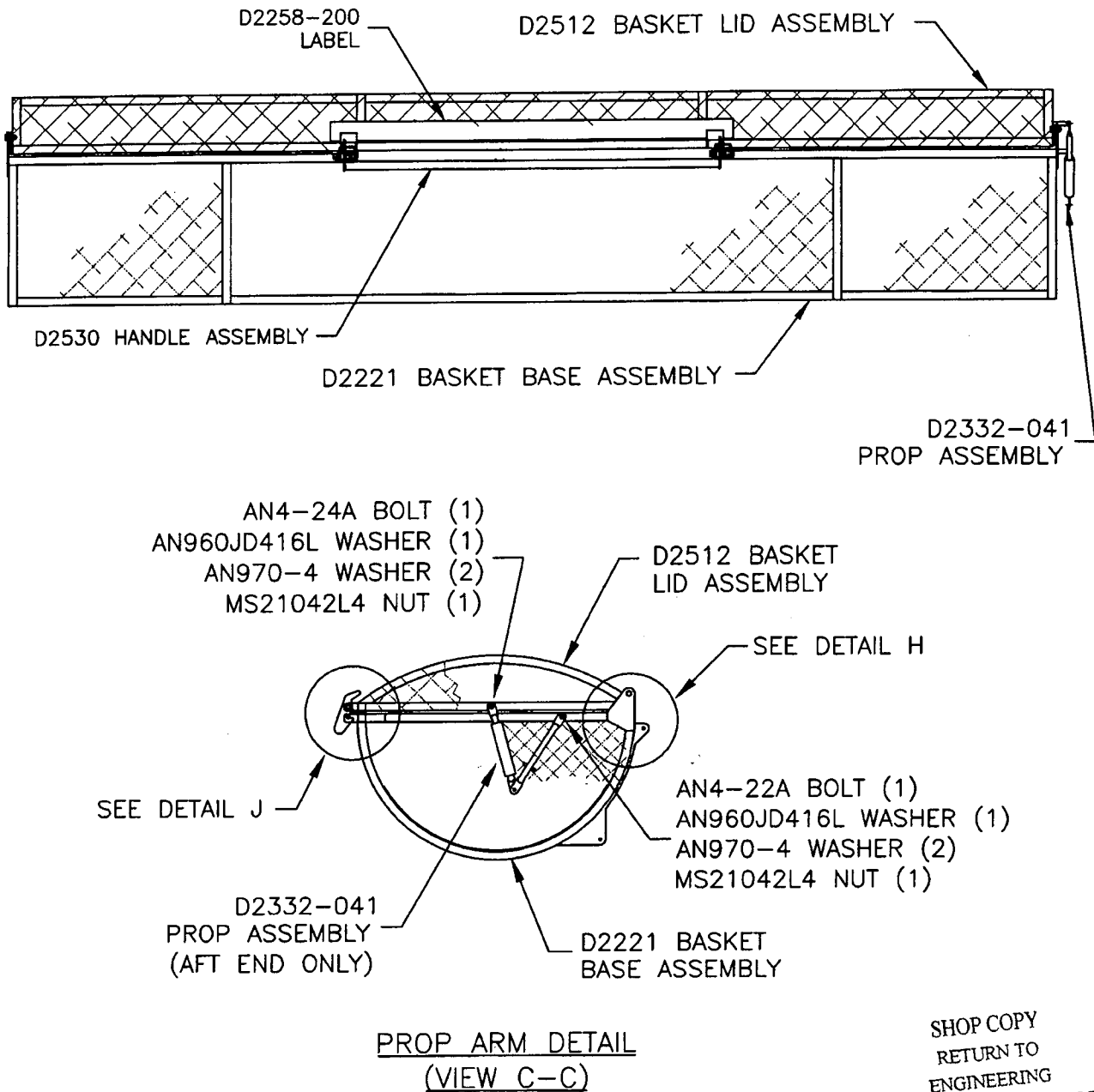


Figure 4 – Basket Replacement Parts
(D350-607-041 Heli-Utility-Basket™)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34531

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Revision: **F**
Date: 03.01.17

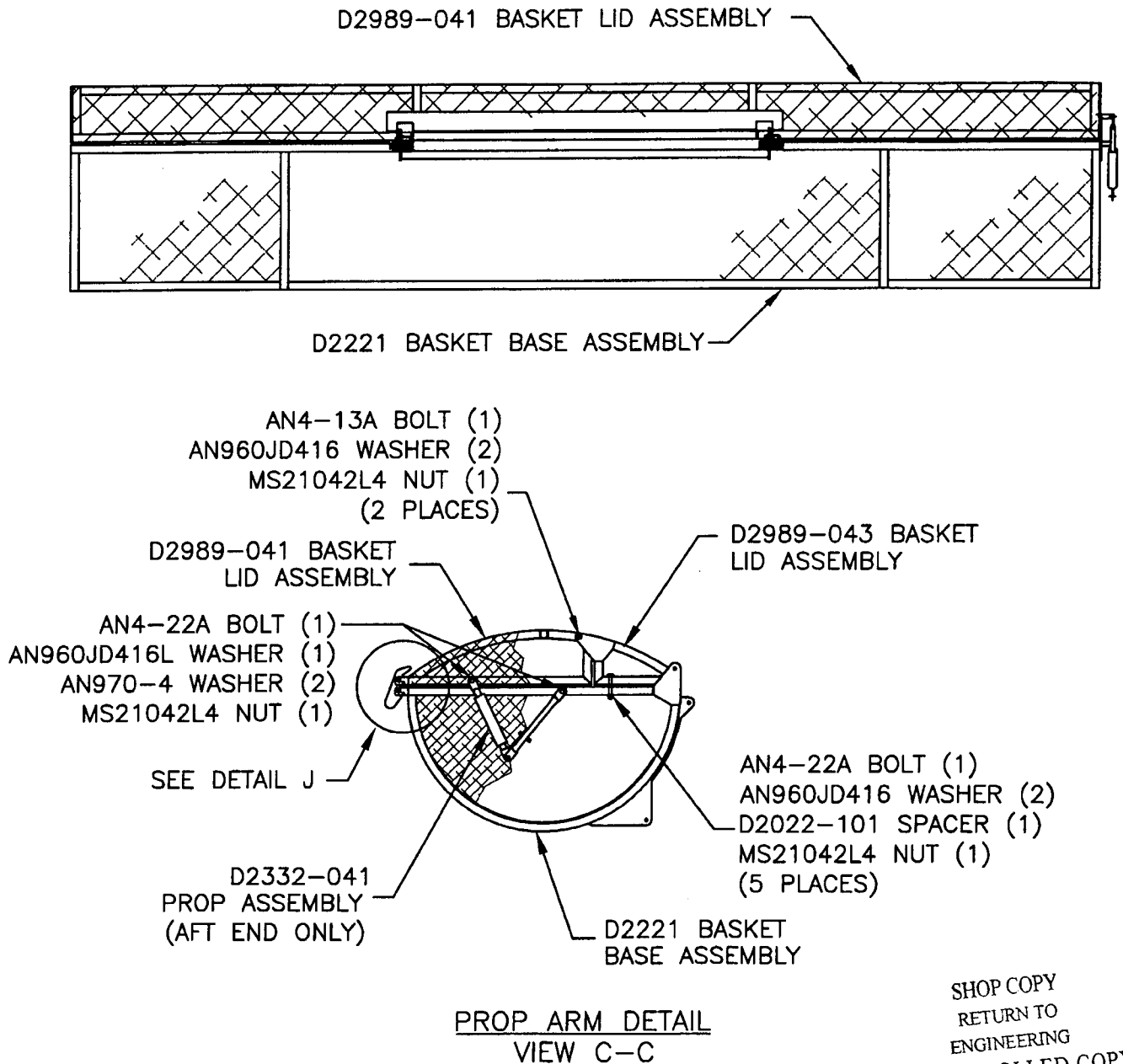
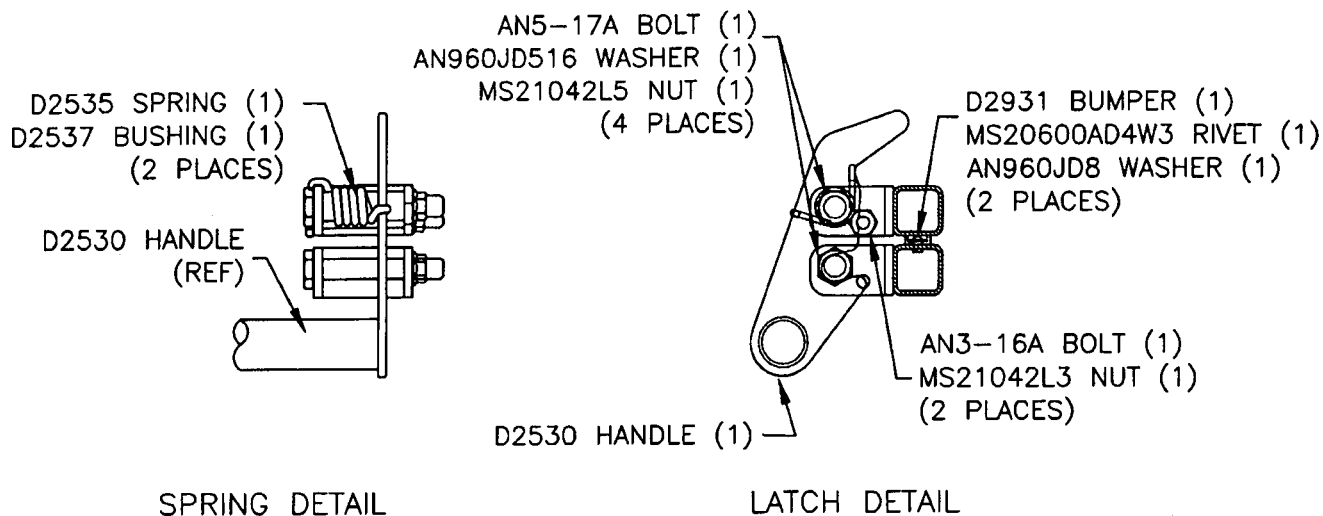


Figure 5- Basket Replacement Parts
(D350-607-043 Heli-Utility-Basket™)

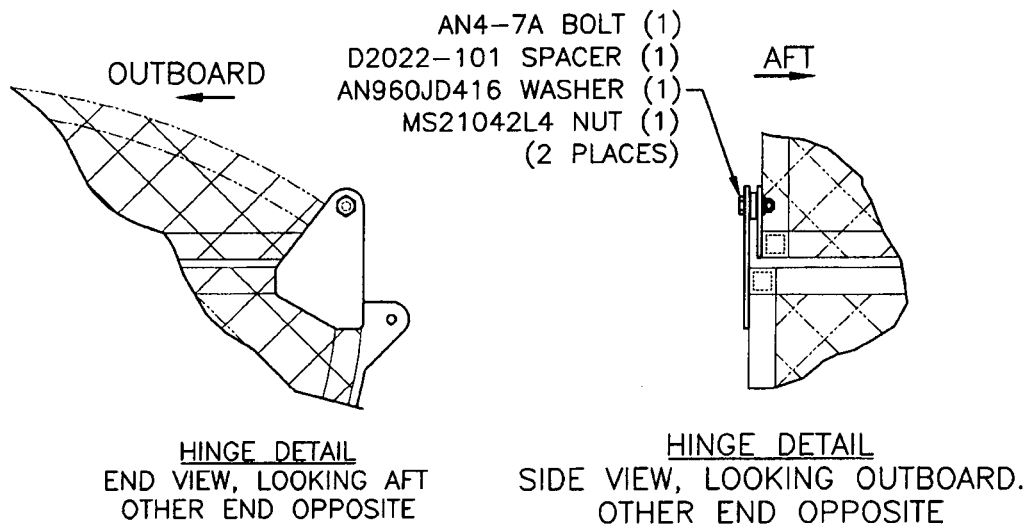
SHOP COPY
RETURN TO
ENGINEERING
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Revision: F
Date: 03.01.17



DETAIL J:
HANDLE WELDMENT



DETAIL H:
HINGE










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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34531

Figure 6 – Basket Replacement Parts

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OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: **F**
Date: 03.01.17

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BASKET BASE ASSEMBLY (350)
Job Number : 34531A	
Estimate Number : 10189	
P.O. Number : N/A	Part Number : D2221
This Issue : 9/11/2007 S.O. No. : N/A	Drawing Number : D2221/D2235
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY	Drawing Revision : F/B1
Previous Run : 34280C	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 9/30/2007 Qty: 1 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est Rev: 05.09.02 Added D3442-1 KJ/JLM	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	D31661 Basket Hoop
	
	
Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)	
Pick:	
Qty Part Number Description Batch	
4 D3166-1 RIB B 34423 J.J.L. 07/10/01	
2.0	D22323 Basket Hinge
	
	
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
Pick:	
Qty Part Number Description Batch	
2 D2232-3 Hinge bracket B 21984 J.J.L. 07/10/01	
3.0	D2325 Support Gusset (350 Bask
	
	
Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)	
Pick:	
Qty Part Number Description Batch	
4 D2325 Support Gusset B 33279 J.J.L. 07/10/01	
4.0	D23273 Spacer Bushing
	
	
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
Pick:	
Qty Part Number Description Batch	
2 D2327-3 Bushing B 33046 J.J.L. 07/10/01	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial -Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 34531A

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2581

Mounting Bracket

B 34445

J.J.L. 07/10/01

6.0

D34421

Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3442-1 Shim

B 33280

J.J.L. 07/10/01

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 41.6745 sf(s)/Unit Total : 41.6745 sf(s)

Pick:

Qty Part Number Description Batch

39.69 sf M304EX0.75-16F Expanded Metal

M 105497

J.J.L. 07/10/01

8.0

M304TS0750W065

304 SQ Tube .75x.75x.065W



Comment: Qty.: 29.4000 f(s)/Unit Total : 29.4000 f(s)

Pick:

28' 3/4" x 3/4" x 0.063 wall 304/316 SStubing

Batch: M 105604

J.J.L. 07/10/01

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235

2-Drill hole in D2221-3 as per Dwg D2221

3-Deburr

4-Remove all markings on material before welding

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required

J.J.L. 07/10/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/12/05
 QA: N/C Closed: _____ Date: _____

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Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 34531A

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-10-01 (1)

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

PD 07-10-01 (1)

12.0

POWDER COATING

POWDER COATING



M105068



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

SA 07-10-02 (1)

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SAD 07-10-04

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(1)
L2010/05

Job Completion



u 07-10-05

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries



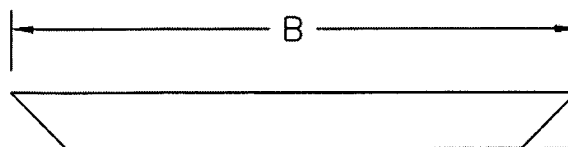
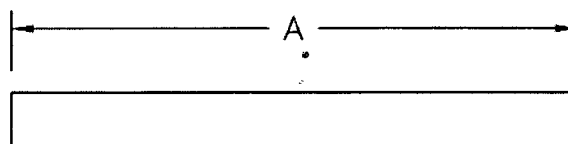
DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2221	REV. F SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350)	SCALE NTS
C	95.11.21	SEPARATE BASKET AND LID	
D	96.06.21	CHANGE LATCH	
E	01.04.19	CHANGE HINGE	
F	05.06.07	-ADD SHIM UNDER HINGES, ADD HOLES FOR SPLIT LID BASKETS	

RELEASED

05.08.19 *[Signature]*

PARTS LIST FOR D2221 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2221-1	2	—	96.00	RIB
D2221-3	2	—	25.50	RIB
D2221-5	2	18.88 $\frac{7}{8}$	—	RIB
D2221-7	1	55.25	—	RIB
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-1	4	N/A	N/A	RIB
D2325	4	N/A	N/A	SUPPORT GUSSET
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MTG BRKT
D3442-1	2	N/A	N/A	SHIM



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WORK ORDER
NO. 34531A



D2221-1/-3/-5/-7

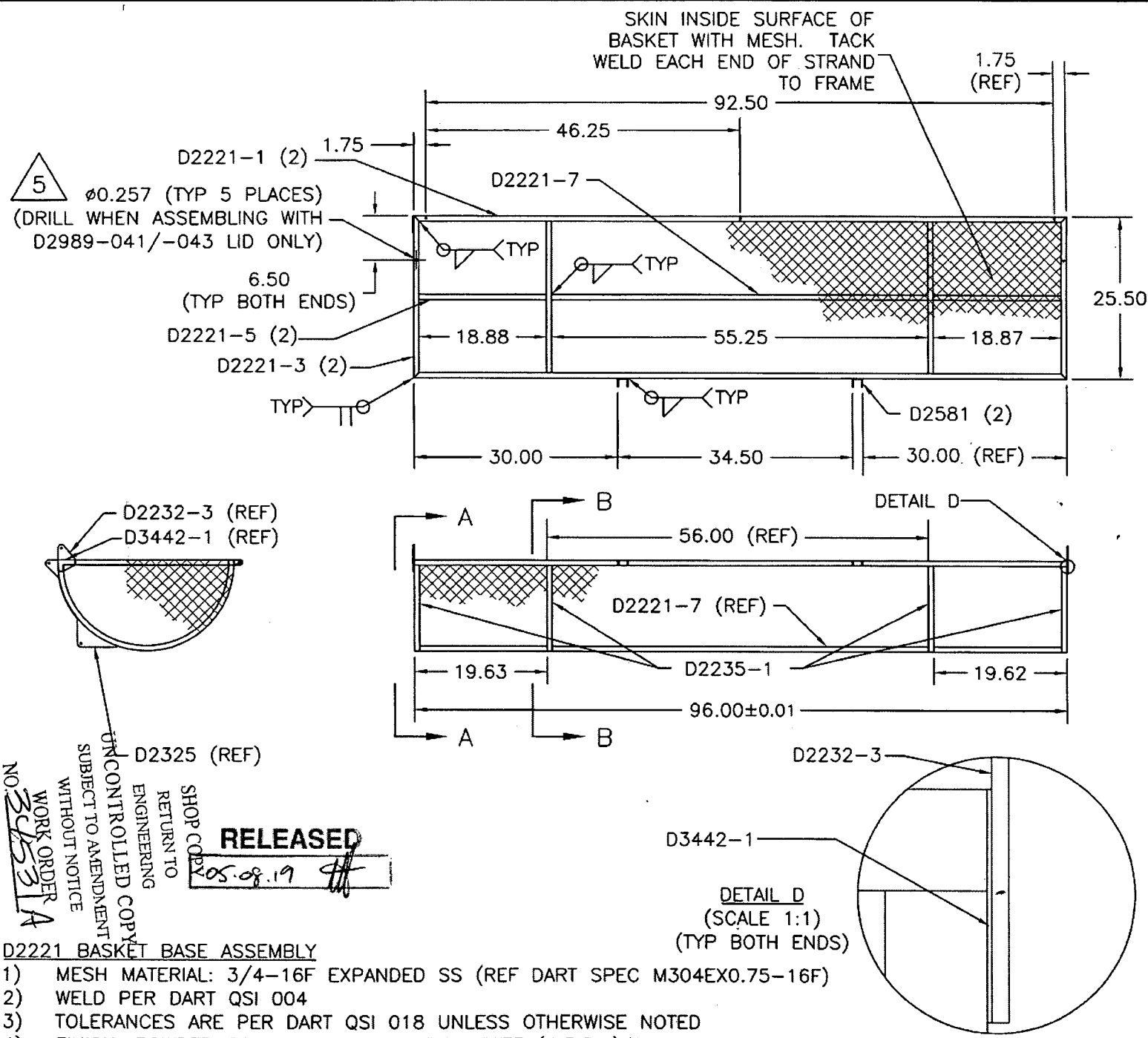
- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING
(REF. DART SPEC M304TS0.750W.060)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) DRILL $\phi 0.257$ HOLES ONLY WHEN ASSEMBLING D2221 BASE WITH
D2989-041/-043 BASKET LID

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DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DESIGN		DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
BW		PH			
CHECKED	APPROVED	DRAWING NO.		REV. F	
		D2221		SHEET 2 OF 3	
DATE		TITLE		SCALE	
05.06.07		BASKET BASE ASSEMBLY (350)		1:20	



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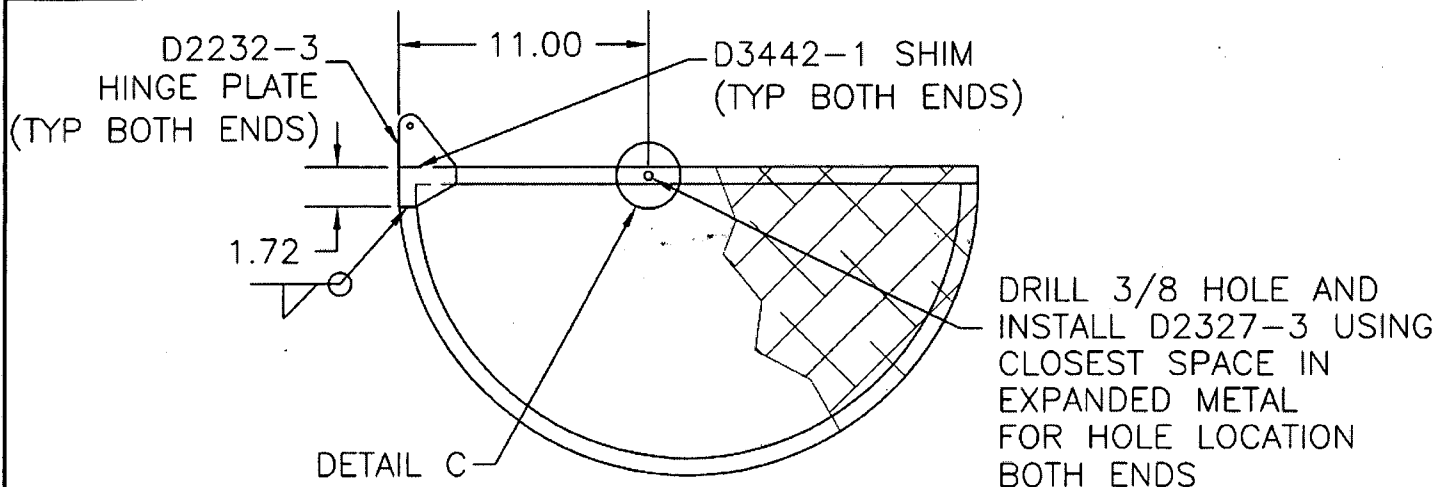
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D2221 BASKET BASE ASSEMBLY

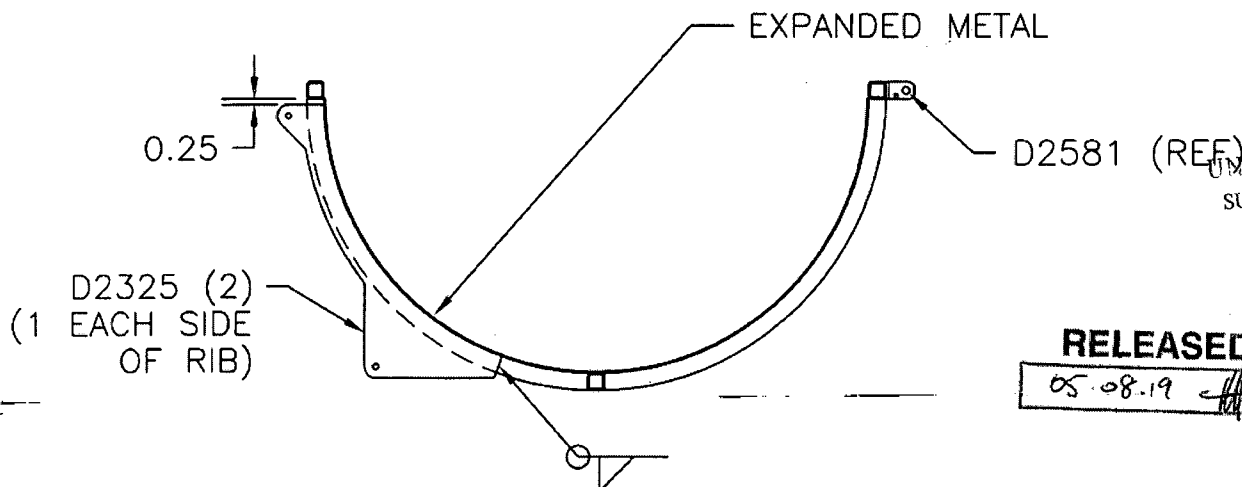
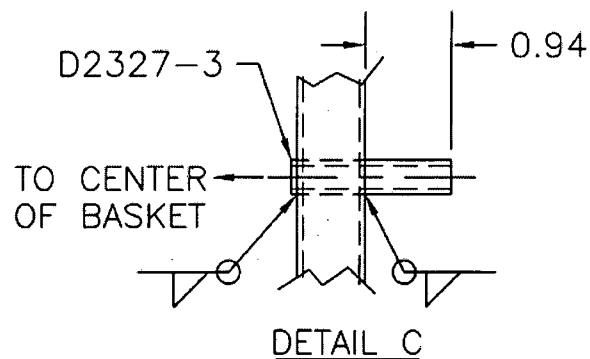
- 1) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3



DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2221	REV. F SHEET 3 OF 3
DATE 05.06.07	TITLE BASKET BASE ASSEMBLY (350)		SCALE 1:8



SECTION A-A SAME BOTH END RIBS



SECTION B-B SAME BOTH CENTER RIBS

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RELEASED

05-08-19 *[Signature]*

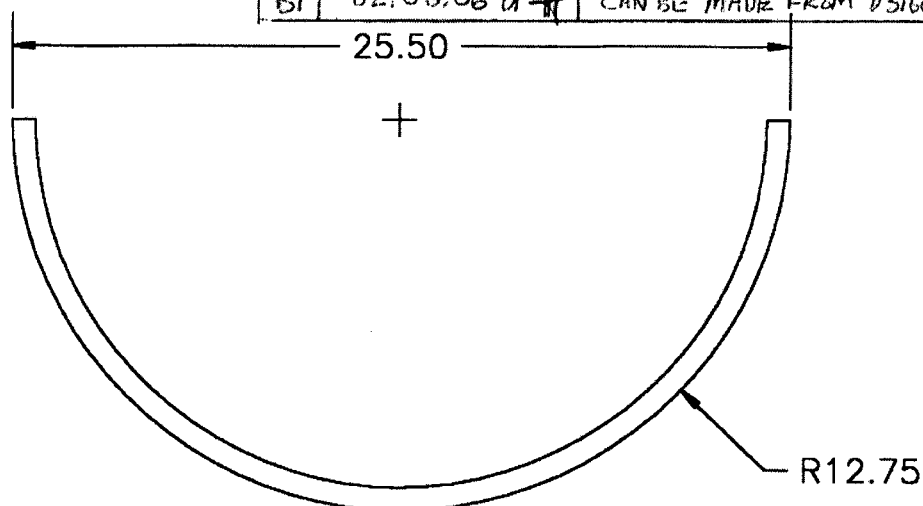
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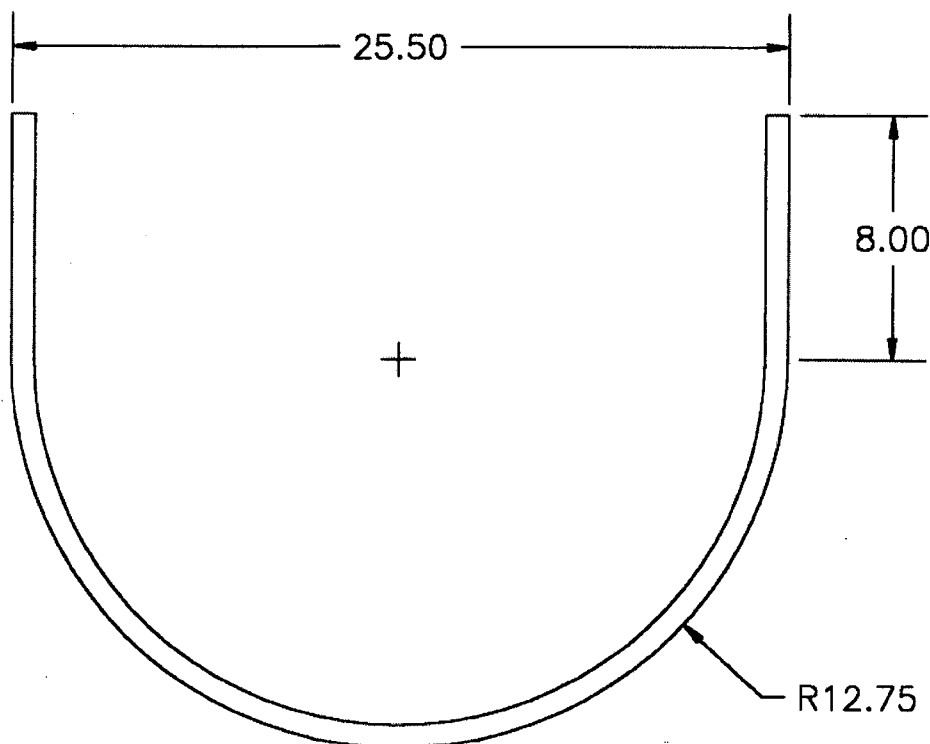


DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. B
CHECKED	APPROVED	D2235	SHEET 1 OF 1
DATE	TITLE		SCALE
94:12:16	BASKET RIBS		
BI	02.08.06	CAN BE MADE FROM D3166-1	


RELEASED
R 960507



D2235-1



D2235-3

CAN BE MADE FROM D3166-1 
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR. NO. 34531A

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WORK ORDER

Date: Tuesday, 9/11/2007 10:24:48 AM
 User: Kim Johnston

Process Sheet

40

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350/212/130 BASKET LID
 Job Number : 34531B
 Estimate Number : 10193
 P.O. Number :
 This Issue : 9/11/2007 S.O. No. :
 Prsht Rev. : NC Part Number : D2512
 First Issue : / / Type : LARGE FAB ASSY Drawing Number : D2512 REV D2
 Previous Run : 34278B Drawing Revision : D2
 Material :
 Due Date : 9/30/2007 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : 07.09.11
 Comment : Rev Est:M 03.01.31 Added D2012-117 for D130-701-041 KJ/RF
 Est Rev:N 06.04.05 Added level21 EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TS0750W065 304 SQ Tube.75x.75x.065W



Comment: Qty.: 45.7594 f(s)/Unit Total : 45.7594 f(s)

Pick:

3/4"x3/4" 304/316 SS tube .063" wall

Batch: 105604

J.J.L. 07/10/01

2.0 D31663 Basket Hoop



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3166-3 Basket Hoop

332068

J.J.L. 07/10/01

3.0 D2506 Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2506 Label Plate

33449

J.J.L. 07/10/01

4.0 D23271 Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2327-1 Bushing

33693

J.J.L. 07/10/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 9/11/2007 10:24:48 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 34531B

Part Number: D2512

Job Number:



- Seq. #:	Machine Or Operation:	Description :
-----------	-----------------------	---------------

5.0	D22321	Hinge
-----	--------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description

2 D2232-1 Hinge plate

Batch

B31608

J.J.L. 07/10/01

6.0	D2581	Mounting Bracket
-----	-------	------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description

2 D2581 Mounting Bracket

Batch

B 34445

J.J.L. 07/10/01

7.0	M304EX07516F	Expanded Metal Flat Stai
-----	--------------	--------------------------



Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s)

Pick:

Qty Part Number Description

18 sf M304EX0.75-16F Expanded Metal

Batch

M105497

J.J.L. 07/10/01

8.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

2-Cut (4) D2236 From D3166-3

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required

J.J.L. 07/10/01

9.0	QC9	VISUAL WELDING INSPECTION
-----	-----	---------------------------



Comment: VISUAL WELDING INSPECTION

PD 07-10-01

①

10.0	QC6	DIMENSIONAL CHECK
------	-----	-------------------



Comment: DIMENSIONAL CHECK

PD 07-10-01

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: PD Date: 01/10/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 9/11/2007 10:24:48 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 34531B

Part Number: D2512

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

11.0	POWDER COATING	POWDER COATING
------	----------------	----------------



M 105068



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

07-10-02

(1)

12.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
------	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

07-10-03
Batch: M 105694

(1)

13.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
------	-----	---



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-10-04

(1)

14.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

01/10 34531

07-10-05 (1)

15.0	QC21	FINAL INSPECTION/W/O RELEASE
------	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

07-10-05 (1)

Job Completion



07-10-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

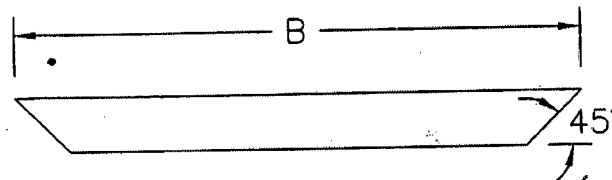
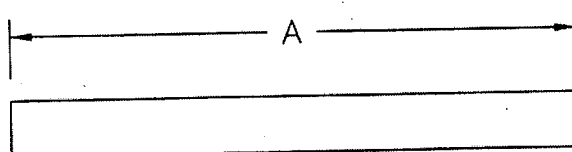


DESIGN BW	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2512	REV. 0 SHEET 1 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	
		SCALE NTS	
A	95.11.21	NEW ISSUE	
B	96.05.24	ADDED LATCH CHANNEL & LABEL PLATE	
C	99.07.06	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP. DEO 9074	
D	01.04.19	CHANGE HINGE	
D1	UP 03.01.20	ADD D2012-117 FOR D130-701-041	
D2	UP 04.09.20	TACK WELD ANT-SKID AREA	

RELEASED
01.04.27 #

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30%	RIB
D2512-5	6	30.84 13/16	—	RIB
D2512-7	3	30.63 5/8	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



D2512-1/-3/-5/-7

CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

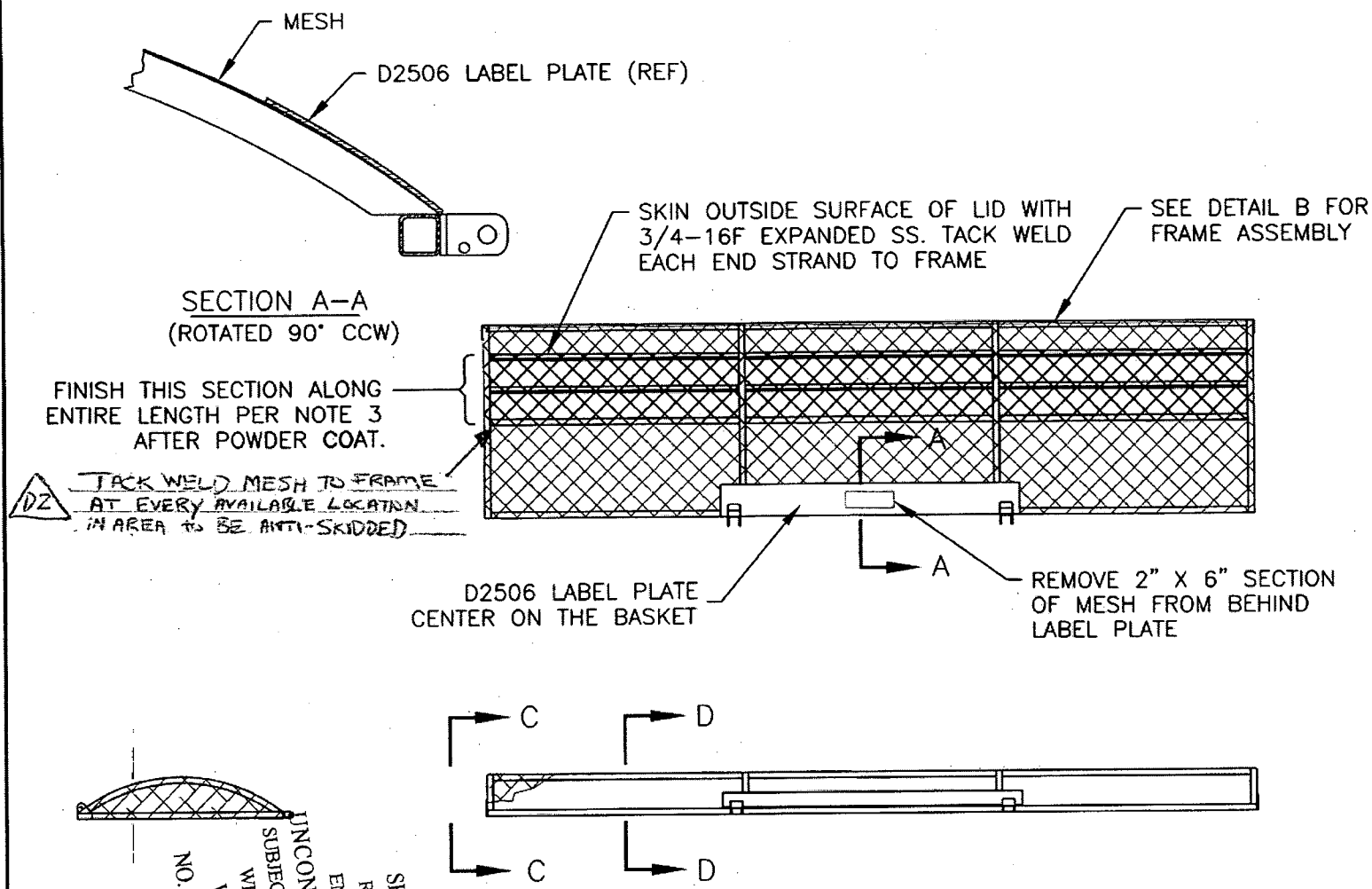
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CHECKED	✓	APPROVED	✓	HAWKESBURY, ONTARIO, CANADA
DATE	01.04.19	DRAWING NO.	D2512	REV. D
		TITLE	BASKET LID ASSEMBLY (350/212)	SHEET 2 OF 4
				SCALE 1:20



- 512 BASKET LID ASSEMBLY
- MESH MATERIAL: 3/4-16F EXPANDED SS
- FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- SPRAY PAINT BLACK INSIDE SURFACE
- APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

NO. 34531B

WORK ORDER

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01.04.21

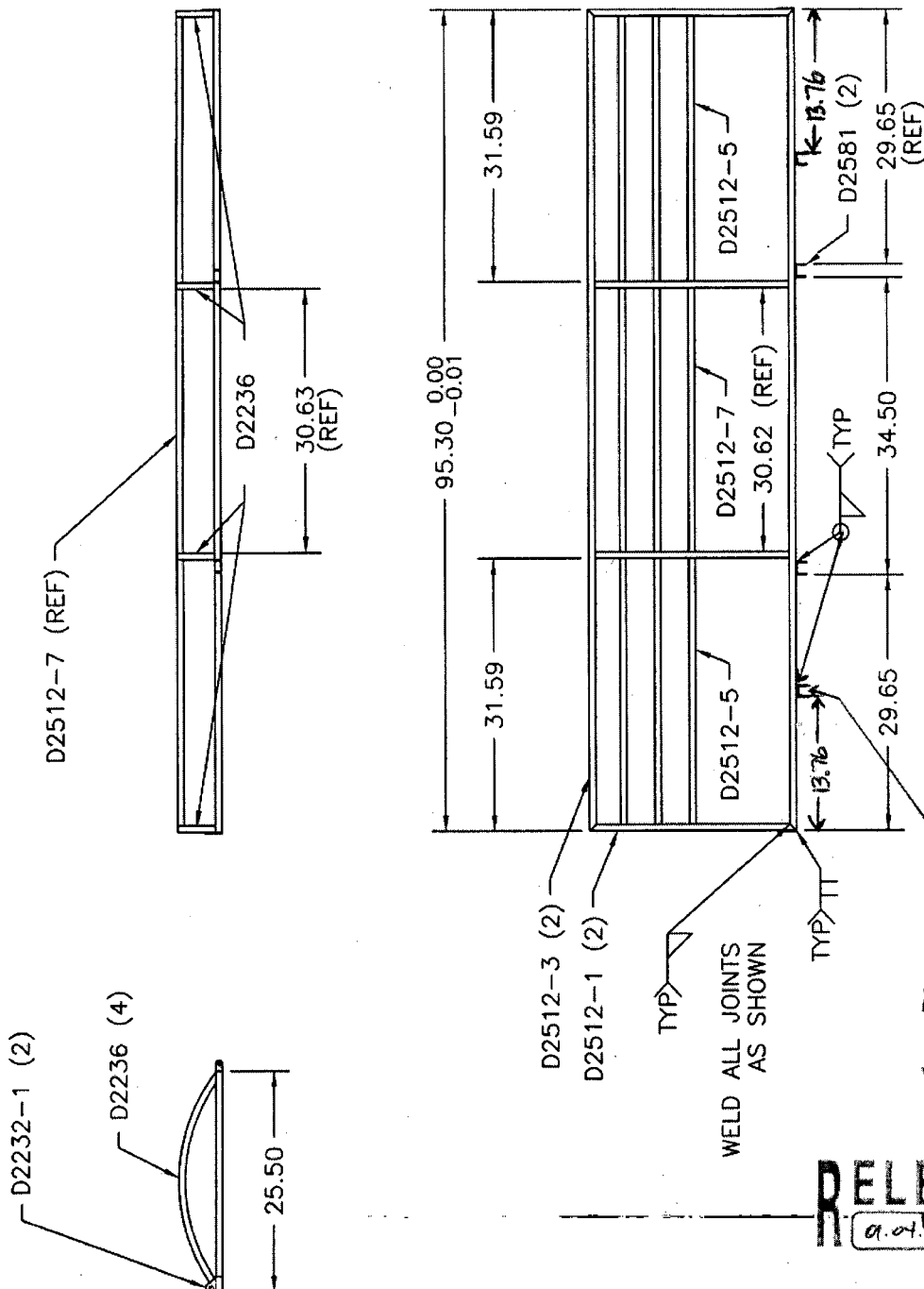
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CHECKED #	APPROVED #	DRAWING NO. D2512	REV. D SHEET 3 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	SCALE 1:20



DETAIL B
FRAMEWORK SHOWN FOR CLARITY
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

D2012-117 CLEANS
ADD FOR D130-701-041
ONLY (2 PLACES)



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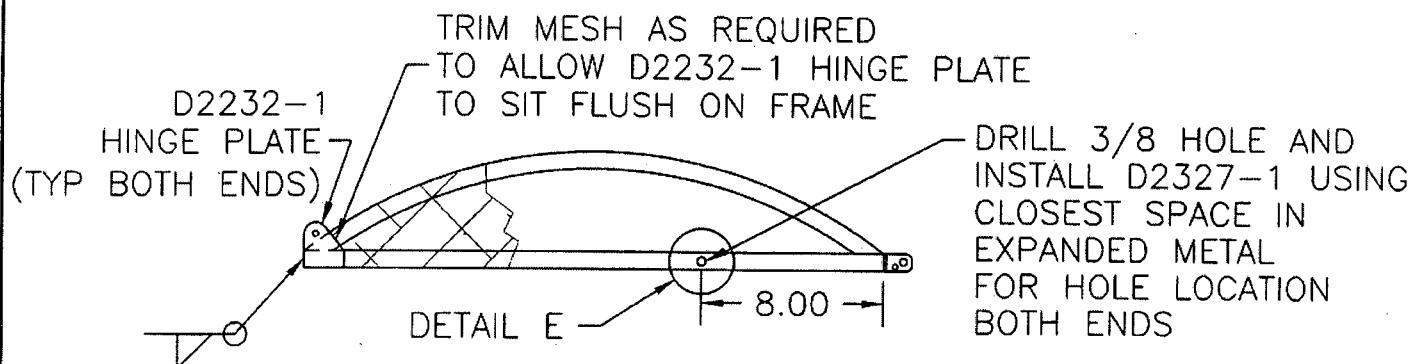
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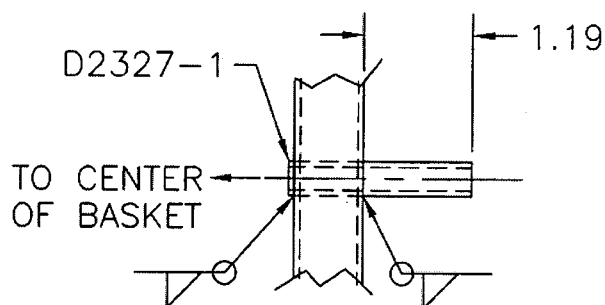
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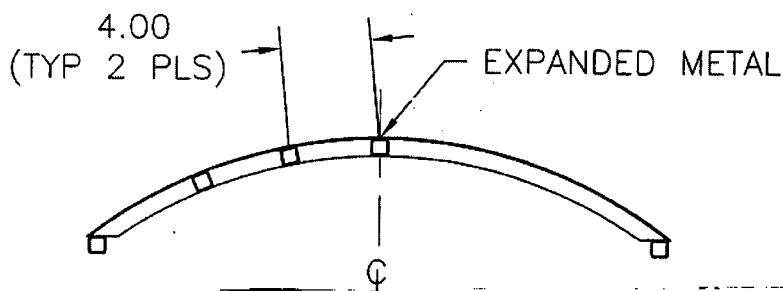
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2512	REV. D SHEET 4 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	SCALE 1:8



SECTION C-C SIMILIAR BOTH END RIBS



DETAIL E



SECTION D-D SAME BOTH CENTER RIBS

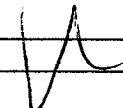
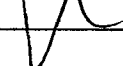
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Date: Thursday, 06/12/2007 11:02:02 AM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D350-607/D130-701
Job Number : 36168	
Estimate Number : 10804	
P.O. Number : N/A	Part Number : Z_CUSTOM
This Issue : 06/12/2007 S.O. No. : N/A	Drawing Number : ECN 1082
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY	Drawing Revision : N/A
Previous Run : 00015	Material : N/A
Written By : 	Due Date : 13/12/2007
Checked & Approved By : 	Qty: 1 Um: Each
Comment :	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

REMOVE FROM STK:

D130-701-041

31938

34534

34227

32299

35345

34531

D350-607-041

33228

33724

34278

35525

35526

35347

D350-607-043

34279

35346

35105

D350-607-045

31773

31086

31087

35904

D350-607-047

ADD NEW PAPERWORK TO KITS IN STOCK
 EASA STC, PER ECN 1082

1/12/07 SD 19X

RETURN TO STOCK

2.0	QC21	FINAL INSPECTION/W/O RELEASE
-----	------	------------------------------



①

Comment: FINAL INSPECTION/W/O RELEASE

12/12/11

Job Completion



W 07.12.11

Date: Tuesday, 20/11/2007 12:42:02 PM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.
 Job Number : 35902
 Estimate Number : 10804
 P.O. Number : *N/A*
 This Issue : 20/11/2007 S.O. No. : *N/A*
 Prsht Rev. : *NC*
 First Issue : *N/A* Type : LARGE FAB ASSY
 Previous Run : 00015
 Written By : *[Signature]*
 Checked & Approved By : *[Signature]*
 Comment :

Drawing Name : D350-607
 Part Number : Z_CUSTOM
 Drawing Number : ECN 1068
 Project Number : *N/A*
 Drawing Revision : *N/A*
 Material : *N/A*
 Due Date : 20/11/2007

Qty: *15* Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 PULL FROM STK:

D350-607-041/42 ch006

D350-607-043/44 ch003

ch001

D350-607-045

D350-607-047

ADD DSI9380-011 KITS TO EACH KIT
 CHANGE WHITE LABEL TO NEW CHG NUMBER
 D350-607-041 - CHG 007
 D350-607-043 - CHG 004
 D350-607-045 - CHG 002
 D350-607-047 - CHG 002

RETURN TO STK

ADD NEW RED DECAL TO KIT AND DSI PAPERWORK

2.0

DSI9380011

RUBBER CUSHION KIT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 18.0000 Each(s)
 RUBBER CUSHION KIT *B35501*

